

**Aero Design Ltd.****Work Order Control Sheet**Work Order#: **2017-143** Date Opened: **29 August 2017** Title: **Assembly**Aircraft OEM: **Eurocopter** Aircraft Model: **AS350/355** Product Type: **Cargo Basket** Product Model: **Long** Quantity: **1****Work Order Contents**

Work Order/Build Sheets (Procedures Provided)  
Additional Work Sheets (Standard Practice)  
Drawings (See List Below)  
Parts Distribution Sheet  
Sub Component Tags  
Completed Certification  
Time Sheet (R&D)  
Notes

Initial or N/A

JC

N/A

JC

JC

N/A

JC

N/A

N/A

**Build Sheet Contents**

Tasks Initialled  
Dual Inspections Initialled

Initial or N/A

JC

JC

**Drawing List**

Drawing #	Rev #	Description	Initial or N/A
78410	2	Basket Assembly	JC
78427	2	Placard	JC
70405	4	Lid Walkway	JC
84255	2	Handle Installation	JC
84240	0	Lid Prop Installation	JC
84261	2	Handle Assembly	JC

**Traveller**

Install walkway on lid  
Install lid on basket body  
Re-tap mounting lug holes and install mount lugs  
Install handle brackets  
Install handle  
Install lid prop  
Install data plate

Initial or N/A

JC

JC

JC

JC

JC

JC

JC

Work performed by:

Print: J. Clarke

ICC / Dual Inspection performed by:

Print: J. Rekve

Work Order closed by:

Print: J. Clarke

Approved Manufacturing Facility 73-04

Sign: Sign: Sign: 

Form 20.0.03

**Component Completion**

Quantity Complete on This Work Order  
Quantity Incomplete on This Work Order  
Further Processing Required Before Release  
Release to Stock as Components

As Instructed

1

N/A

N/A

N/A

**Certification**

Form One Completed  
Serviceable (Green) Tag Completed  
In Process (Yellow) Tag Completed  
Unserviceable (Red) Tag Completed  
Parts Placed in Stores for Distribution

Initial or N/A

JC

N/A

N/A

N/A

N/A

**Additional Documentation**

Documentation of a minor change  
Non-Conformance Report Required  
Service Difficulty Report Required

Initial or N/A

N/A

N/A

N/A

**Billing**

Local (Aero Design)  
Research and Development  
Third Party

Initial or N/A

JC

N/A

N/A

SCA: AD02Date: 30-Aug-17SCA: AD01Date: 30-Aug-17SCA: AD02Date: 31-Aug-17

Rev. Original 23 Sep 2014



Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC  
V8A 0G3, 604-483-AERO (2376)

Quantity:	1	
PN:	Tread Plate	
Aircraft:	All	Model: N/A
Description:	Lid Walkway Checker Plate	
Supplier:	Daigle Marine	
Color:	Aluminum	
WO#:	N/A	PO# 17011



## Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC  
V8A 0G3, 604-483-AERO (2376)

Quantity: 1

PN: MS20001P4-9600

Aircraft: All

Model: All

Description: Hinge

Supplier: GKN Aerospace Bandy Machining

Color: N/A

WO#: N/A

PO# 17017



## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: AS350 Long Lid No. of pieces: 1

Manufacturer: Aero Design

Part No.: 78412-01 Serial/Batch No.: NSN

TTSN: NP TSO: N/A Rem.: N/A

Work Order No.: 2017-24

Remaining Tasks to be Performed: Assemble

\_\_\_\_\_

\_\_\_\_\_

Signature: [Signature]

Date: 11 Apr 17 Lic. No. / SCA AD 01

Serviceable



## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: A350 Long body No. of pieces: 1

Manufacturer: Aero Design

Part No.: 78411-C1 Serial/Batch No.: NSN

TTSN: NP TSO: N/A Rem.: N/A

Work Order No.: 2017-24

Remaining Tasks to be Performed: Assemble

Signature: [Signature]

Date: 11 Apr 17 Lic. No. / SCA AD01

Form# 20.E.02 Rev. 1 24 April 2014

Serviceable



## CARGO BASKET HANDLE ASSEMBLY

### General

These instructions apply to all cargo basket handle assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

All Models: 84261, Rev. 1

Work Order: 2017-143

Date Open: 29 AUG 2017

Complete  
(initial or SCA #)

#### 1. Fabricate Handle Assembly

- a. Temporarily install handle levers on lid assembly. Ensure long side of handle bushings are on INSIDE (pointing together).
- b. Measure across TOP side of levers.
- c. Cut handle tubing to length measured.
  - i. Handles under 40" long: 1.0" x 0.035 round tube
  - ii. Handles over 40" long: 1.0" x 0.065 round tube
- d. De-burr tube.
- e. Insert tube into handle levers. Tap with a plastic mallet to seat tube flush with lever. Raise handle to ensure both levers touch stops to check alignment.
- f. Record material PO on attached material list.

#### 2. Weld Handle Assembly

- a. Fuse tube to lever on both ends. Ensure levers are parallel.

#### 3. Clean up

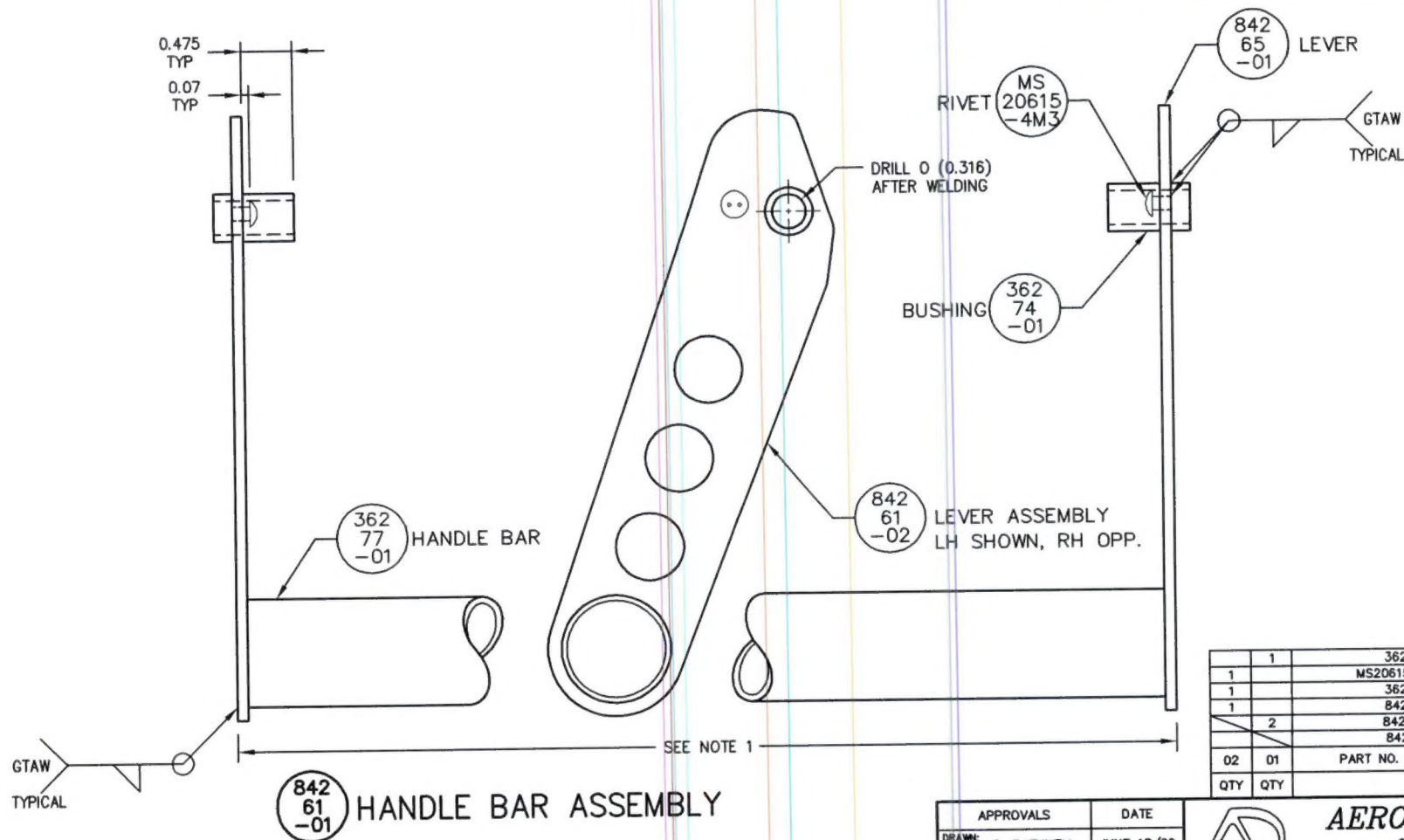
- a. Clean welded area with scotch-brite.

#### 4. Final Inspection

- a. Welds for complete and handle for fit.
- b. Tag complete and inspected parts in preparation for installation.

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	HANDLE END BRACKETS FLIPPED	BJC	SEPT 19/11
2	TITLE BLOCK UPDATED; LEVER ASSEMBLY ASSIGNED P/N	BJC	MAR 13/14



NOTES:

1. LENGTH OF HANDLE TO BE DETERMINED BY BASKET ASSEMBLY DRAWING.
2. REMOVE ALL BURRS AND SHARP EDGES.
3. WELDING TO BE COMPLETED BY GTAW METHOD TO AMS2685C USING ER308L ROD.

QTY	QTY	PART NO.	DESCRIPTION
1		36277-01	HANDLE BAR
1		MS20615-4M3	RIVET (MONEL)
1		36274-01	BUSHING
1		84265-01	LEVER
2		84261-02	LEVER ASSEMBLY (RH/LH)
2		84261-01	HANDLE BAR ASSY

APPROVALS	DATE
DRAWN: R. RATHWELL	JUNE 18/09
CHECKED: E. BURGAIN	

UNLESS OTHERWISE SPECIFIED  
DIMENSIONS ARE IN INCHES.  
TOLERANCES ON:  
DECIMALS ANGLES  
X.XXX ±0.010 ±1/2°  
X.XX ±0.03  
X.X ±0.1



**AERO DESIGN LTD.**

9888A MALASPINA ROAD  
POWELL RIVER, BC, CANADA, V8A 0G3  
TEL: 604.485.8378 www.aerodesign.ca

**HELICOPTER CARGO BASKET  
HANDLE BAR ASSEMBLY**

SCALE	DWG. SIZE	DWG. NO.	REV.
SCALE 1 : 1	A3	84261	2
SHEET 1 OF 1			

Work Order: 2017-143Date Opened: 28 Aug 2017Material Tracking Sheet  
Eurocopter AS350 / AS355  
Long Handle Assembly

1 of 1

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	<u>1</u>	84261	<b>84261-01</b>	<b>Handle Assembly</b>		
<b>Step 1</b>				<i>Weld Lever Assembly</i>		<i>2017-65</i>
	. 2		84265-01	Lever	304 Stainless, 0.105 Sheet	
	. 2		36274-01	Bushing	304 Stainless, 7/16" x 0.065 Rnd. Tube	
	. 2		MS20615-4M3	Rivet		
	. A/R		--	Welding Rod	ER308L TIG Rod	
<b>Step 2</b>				<i>Clean Up</i>	<i>None</i>	
<b>Step 3</b>				<i>Fabricate Handle Bar</i>		
	. 1		36277-01	Handle Bar	304 Stainless, 1.0 x 0.065 Rnd. Tube	<i>17050</i>
<b>Step 4</b>				<i>Weld Handle Assembly</i>	<i>None - Fuse weld, no rod req.</i>	
<b>Step 5</b>				<i>Clean Up</i>	<i>None</i>	
<b>Step 6</b>				<i>Inspection - Final Assembly</i>	<i>None</i>	



# CARGO BASKET ASSEMBLY - COMMON

Work Order: 2017-143

Date Open: 29 AUG 2017

## General

These instructions apply to all cargo basket assemblies. Refer to the following drawings, at the current revision, for dimensions and details. Drawings are linked to the source for ease of printing.

		Basket			Lid Walk	Lid Prop	Handle		
✓	Basket Type	Ass'y	Placard	Mat'l			Inst'n	Ass'y	Mat'l
Bell 206B – right side only									
	Short	<a href="#">80210</a>	<a href="#">80227</a>	<a href="#">Mat'l</a>	70405	<a href="#">84240</a>	<a href="#">84255</a>	<a href="#">84261</a>	<a href="#">Mat'l</a>
	Medium	<a href="#">80310</a>	<a href="#">80327</a>	<a href="#">Mat'l</a>					<a href="#">Mat'l</a>
	Long	<a href="#">81110</a>	<a href="#">81127</a>	<a href="#">Mat'l</a>					<a href="#">Mat'l</a>
Bell 206L/407 – Right side only									
	Low Standard	<a href="#">69810</a>	<a href="#">69827</a>	<a href="#">Mat'l</a>	70405	<a href="#">84240</a>	<a href="#">84255</a>	<a href="#">84261</a>	<a href="#">Mat'l</a>
	Low Wide	<a href="#">94510</a>	<a href="#">94527</a>	<a href="#">Mat'l</a>					<a href="#">Mat'l</a>
	Low Ski	<a href="#">94610</a>	<a href="#">94627</a>	<a href="#">Mat'l</a>					<a href="#">Mat'l</a>
	High Ski	76610	76625	Mat'l					<a href="#">Mat'l</a>
Bell Medium – left or right									
	Standard	75110	75127	Mat'l	70405	<a href="#">84240</a>	<a href="#">84255</a>	<a href="#">84261</a>	<a href="#">Mat'l</a>
	Extra Large (ski)	95510	95527	Mat'l					<a href="#">Mat'l</a>
	Mega	100610	100627	Mat'l					<a href="#">Mat'l</a>
Bell 429 – right or left									
	Standard – Pre S/N 71	95910	95927	Mat'l	70405	<a href="#">84240</a>	<a href="#">84255</a>	<a href="#">84261</a>	<a href="#">Mat'l</a>
	Standard – Post S/N 71	95950	95927	Mat'l					<a href="#">Mat'l</a>
Eurocopter AS350/AS355 – left or right									
	Short	77610	77627	Mat'l	70405	<a href="#">84240</a>	<a href="#">84255</a>	<a href="#">84261</a>	<a href="#">Mat'l</a>
	Medium	76410	76427	Mat'l					<a href="#">Mat'l</a>
✓	Long	78410	78427	Mat'l					<a href="#">Mat'l</a>
	Ski	94010	94027	Mat'l					<a href="#">Mat'l</a>
Robinson R44 – left or right									
	Standard	90610	90627	Mat'l	<a href="#">70405</a>	<a href="#">84240</a>	<a href="#">84255</a>	<a href="#">84261</a>	<a href="#">Mat'l</a>
MD600									
	Standard	82810	82827	Mat'l	<a href="#">70405</a>	<a href="#">84240</a>	<a href="#">84255</a>	<a href="#">84261</a>	<a href="#">Mat'l</a>

Hyperlinking to specific excel sheet –

1. on desired excel sheet cell A1, set name of cell, eg. Assembly.
2. at end of hyperlink add #Assembly (filename.xls#Assembly).



## 1. Lid Assembly

## a. Install lid bumpers on bottom.

- i. Drill  $\frac{1}{4}$ " holes using center drill, 3 (standard/medium) or 4 (long/ski) places.
- ii. Fill bumper holes with RTV silicone sealant.
- iii. Insert 49205-14 lid bumper, 3 or 4 places per lid.

## b. Install placard on bracket on top of lid

Note: 959 and 1006 placard is installed on body.

- i. Locate placard on bracket.
- ii. Drill #30 through placard and bracket, using holes in placard.
- iii. Remove placard and de-burr holes in placard and on bracket.
- iv. Locate placard on bracket, and cleco in place.
- v. Rivet placard with four CR3213-4-02 CherryMax rivets.

## c. Option: Install walkway on top of lid (lid must be fitted with walkway provisions)

- i. Note: avoid touching surface of tread plate with bare hands to prevent smudges or marks on the top surface.
- ii. Pull tread plate from stock. Shear tread plate to length.
- iii. De-burr edges of tread plate with scotch-brite wheel on bench grinder.
- iv. Locate tread plate on lid. Hold tread plate in place with bags of lead shot.
- v. Mark and drill #30 holes:
  1. 0.25" from edge of tread plate, centre on cross members (0.38")
  2. 0.25" from edge of tread plate, middle of each walkway stringer
- vi. De-burr and counter-bore (if required to provide clearance of rivet head on checker pattern) all holes in tread plate using  $\frac{1}{4}$ " piloted counter bore on both sides.
- vii. De-burr holes in lid tubes.
- viii. Apply bead of RTV silicone sealant along all tubes under tread plate.
- ix. Set tread plate in place, secure with clecos if necessary.
- x. Rivet placard with CR3213-4-02 CherryMax rivets

## d. Record PO/WO of all parts (including lid) used in steps above on attached material tracking list.

## 2. Body Assembly



## a. Install attachment fittings

- i. Carefully remove excess powder coat from around attachment lug threads using a countersink.
- ii. Run 3/8-24 tap into attachment lugs to clear threads.
- iii. Apply anti-seize compound to attachment fittings 96710-01 (alternate: Ancra 40088-14)
- iv. Install attachment fittings with two NAS1149F0363P washers in four lugs in basket.
  1. 90610 (Robinson R44) basket only:
    - a. Install 1 fitting 90628-01 in lower forward attachment lug only.
    - b. Install 3 96710-01 fittings in remaining locations.
- v. Torque to 160-190 in-lbs (13.3-15.8 ft-lbs).



- b. 959 and 1006 Baskets only: Install inboard sheet on upper rim of basket
  - i. Locate sheet on basket.
  - ii. Drill #30 through sheet and rim, located as specified on drawing. Cleco in place.
  - iii. Remove sheet and de-burr holes in sheet and rim.
  - iv. Apply bead of RTV silicone sealant along all tubes under sheet.
  - v. Locate sheet on basket, and cleco in place.
  - vi. Rivet sheet with CR3213-4-02 CherryMax rivets.
- c. 959 Basket only: Install forward sheet
  - i. Locate sheet on basket. Ensure sufficient clamps are in place.
  - ii. Drill #30 through sheet, rim and hoop, located as specified on drawing. Cleco in place.
  - iii. Remove sheet and de-burr holes in sheet and rim.
  - iv. Apply bead of Pro-Seal sealant along all tubes under sheet.
  - v. Locate sheet on basket, and cleco in place.
  - vi. Rivet sheet with CR3213-4-02 CherryMax rivets.
- d. Record PO/WO of all parts (including basket) used in steps above on attached material tracking list.

### 3. Hinge Installation

#### a. Prepare hinge.

- i. Cut hinge to length:
  - 1. 776, 906 – 54"
  - 2. 751, 803 – 70"
  - 3. 698, 764, 945 – 72"
  - 4. 766, 784 – 90"
  - 5. 940, 946, 959 – 95"
  - 6. 1006 – 107"
- ii. Drill #30 pilot holes using hinge jig. For long hinges, flip at specified location on jig.

#### b. Install hinge on basket

- i. Locate hinge on basket (standard baskets)
  - 1. centre fore/aft
  - 2. 0.15" – 0.18" up from bottom edge
- ii. Locate hinge on basket (extra wide baskets)
  - 1. centre fore/aft
  - 2. set hinge at 90 degrees (as if lid would be installed) using a small square, locate vertical side at 22.5" from outboard edge.
- iii. Drill #30 through holes in hinge into basket rim. Cleco in place with 1/8 (copper) clecos.
- iv. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 (black) clecos.
- v. Remove hinge and de-burr holes in hinge and basket rim.
- vi. Cleco hinge to basket with 5/32 clecos.
- vii. Install hinge with CherryMax rivets
  - 1. CR3523-5-02 monel rivets – last 2 rivets in each end
  - 2. CR3213-5-02 aluminum rivets – all other locations

- c. Install lid on basket
  - i. Locate lid on hinge (all baskets)
    - 1. center fore/aft
    - 2. 0.15" – 0.18" down from top edge
  - ii. Drill #30 through holes in hinge into lid rim. Cleco in place with 1/8 clecos.
  - iii. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 clecos.
  - iv. Remove hinge and de-burr holes in hinge and lid rim.
  - v. Cleco lid to hinge with 5/32 clecos.
  - vi. Install hinge with CherryMax rivets
    - 1. CR3523-5-02 monel rivets – last 2 rivets in each end
    - 2. CR3213-5-02 aluminum rivets – all other locations
- d. Record PO of hinge and rivets on attached material tracking list.

#### 4. Install Handle

- a. Install handle brackets.
  - i. Set 84267-01 handle bracket on provisions in hoops, 2 places.
  - ii. Install AN3-11A bolt, NAS1149F0363P washer (2), MS21044N3 nut. Two places per bracket, two brackets per basket.
  - iii. Torque AN3 bolts to 20-25 in-lbs.
- b. Install handle
  - i. Trim 36278-01R and 36278-01L springs to ensure end of spring does not extend past edge of handle bracket, approximately 1/8". Set springs over bushing of 84261-01 handle assembly.
  - ii. Grease two 36275-01 bushings with Mobil Grease 28 or equivalent. Insert into bushings of handle assembly.
  - iii. Locate handle on basket lid. Insert AN3-12A bolt with NAS1149F0363P through bracket on lid and handle bushing on one end of handle.
  - iv. On other end of handle, hook spring over catch rivet on handle assembly and use spring tool to twist spring to catch arm on bracket on lid while inserting AN3-12A bolt with NAS1149F0363P washer through lid bracket and handle bushing.
  - v. At first end, remove bolt and repeat step iv.
  - vi. Install NAS1149F0363P washer and MS21044N3 nut on both AN3-12A bolts.
  - vii. Torque AN3 bolts to 20-25 in-lbs.
- c. Check handle
  - i. Operate handle to ensure handle does not bind and springs hold handle in.
  - ii. Snap handle into brackets to ensure handle locks.
- d. Record PO/WO of all parts used in steps above on attached material tracking list.



5. Install lid brace

jc.

- a. Locate 36280-01 lid brace on bushing in basket. Ensure brace is on forward end of basket as it will be installed on the helicopter.
- b. On lid end, insert AN970-3 washer into end of lid brace. Insert AN3-15A bolt with NAS1149F0363P washer through AN970-3 washer, lid prop, and lid bushing. Install NAS1149F0363P washer and MS21044N3 nut on bolt.
- c. On basket end, insert AN3-17A bolt with AN970-3 washer through lid prop and basket bushing. Install NAS1149F0363P washer and MS2144N3 nut on bolt.
- d. Ensure brace is seated on lip of bushings before tightening nuts.
- e. Torque AN3 bolts to 20-25 in-lbs.
- f. Record PO/WO of all parts used in steps above on attached material tracking list.

6. 946 Basket Only: Install Cutout Brace

N/A

- a. Locate 94621-01 Brace over aft cross tube cutout.
- b. Install two AN4-6A bolts and two AN4-27A bolts with NAS1149F0463P washers.
- c. Torque AN4 bolts to 50-70 in-lbs.

7. Final Inspection

dk

Dual inspection by a different person than assembled the basket.

- a. Check for general condition and correct assembly:
  - i. Bolts are tight
  - ii. Rivets are installed correctly
  - iii. Handle operates correctly
  - iv. Lid brace operates correctly
- b. Check that PO/WO numbers have been recorded.

Work Order: 2017-143Date Opened: 29 AUG 2017

Material Tracking Sheet  
Eurocopter AS350 / AS355  
Long Basket Assembly

1 of 2

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/NO
	1		78410-01	Cargo Basket Assembly	S/N 7869 78401-68	
<b>Step 1</b>				<i>Lid Assembly</i>		
	1		78412-01	Basket Lid Assembly		2017-24
Step 1.a.	4		49205-14	Bumper	Argus Industries Bumper	See PDS
	A/R		--	Sealant	Commercial Silicone RTV sealant	
Step 1.b.	1		78427-01	Placard	0.063 Sheet, 6061-T6 Aluminum	2015-03
	4		CR3213-4-02	Cherry Rivet		16053
Step 1.c. (option)	1		70405-01	Lid Step Modification		
	1		70405-04	Tread Plate	3003 Aluminum Tread Plate, 0.063"	17011
	A/R		CR3213-4-02	Cherry Rivet		16053
	A/R		--	Sealant	Commercial Silicone RTV sealant	
<b>Step 2</b>				<i>Basket Assembly</i>		
Step 2.a.	1		78411-01	Basket Body Assembly		2017-24
	4		96710-01	Fitting	Alternate: Ancra 40088-14	See PDS
	8		NAS1149F0663P	Washer		See PDS
<b>Step 3</b>				<i>Hinge Installation</i>		
	1		MS20001P4	Piano Hinge	90"	17017
	8		CR3523-5-02	Cherry Rivet		16063
	A/R		CR3213-5-02	Cherry Rivet		16053
<b>Step 4</b>	1		84255-01	Handle Installation		
Step 4.a.	2		84267-01	Bracket	Delrin, 3/4" Sheet	2017-50
	4		AN3-11A	Bolt		See PDS
	8		NAS1149F0363P	Washer		See PDS
	4		MS21044N3	Nut		See PDS

Work Order: 2017-143Date Opened: 29 AUG 2017Material Tracking Sheet  
Eurocopter AS350 / AS355  
Long Basket Assembly

1 of 2

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	1		78410-01	Cargo Basket Assembly	S/N 7869 78401-68	
<b>Step 1</b>				<i>Lid Assembly</i>		
	1		78412-01	Basket Lid Assembly		2017-24
Step 1.a.	4		49205-14	Bumper	Argus Industries Bumper	See PDS
	A/R		--	Sealant	Commercial Silicone RTV sealant	
Step 1.b.	1		78427-01	Placard	0.063 Sheet, 6061-T6 Aluminum	2015-03
	4		CR3213-4-02	Cherry Rivet		16053
Step 1.c. (option)	1		70405-01	Lid Step Modification		
	1		70405-04	Tread Plate	3003 Aluminum Tread Plate, 0.063"	17011
	A/R		CR3213-4-02	Cherry Rivet		16053
	A/R		--	Sealant	Commercial Silicone RTV sealant	
<b>Step 2</b>				<i>Basket Assembly</i>		
Step 2.a.	1		78411-01	Basket Body Assembly		2017-24
	4		96710-01	Fitting	Alternate: Ancra 40088-14	See PDS
	8		NAS1149F0663P	Washer		See PDS
<b>Step 3</b>				<i>Hinge Installation</i>		
	1		MS20001P4	Piano Hinge	90"	17017
	8		CR3523-5-02	Cherry Rivet		16063
	A/R		CR3213-5-02	Cherry Rivet		16053
<b>Step 4</b>	1		84255-01	Handle Installation		
Step 4.a.	2		84267-01	Bracket	Delrin, 3/4" Sheet	2017-50
	4		AN3-11A	Bolt		See PDS
	8		NAS1149F0363P	Washer		See PDS
	4		MS21044N3	Nut		See PDS

Work Order: \_\_\_\_\_

Material Tracking Sheet  
Eurocopter AS350 / AS355  
Long Basket Assembly

2 of 2

Date Opened: \_\_\_\_\_

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 4.b.	.. 1		84261-01	Handle Assembly		See PDS
	.. 2		36278-01	Spring (1 left, 1 right)	304 Stainless, 1/16" Dia Music Wire	see PDS
	.. 2		36275-01	Bushing	Brass, 5/16" Dia	see PDS
	.. 2		AN3-12A	Bolt		see PDS
	.. 4		NAS1149F0363P	Washer		see PDS
	.. 2		MS21044N3	Nut		see PDS
Step 5				Lid Brace Installation		
	. 1		36280-01	Brace Assembly		2017-119
	. 1		AN3-15A	Bolt		see PDS
	. 1		AN3-17A	Bolt		see PDS
	. 2		AN970-3	Washer		see PDS
	. 3		NAS1149F0363P	Washer		see PDS
	. 2		MS21044N3	Nut		see PDS
Step 6				Inspection	None	





**Description:** Basket Assembly Kit

WO# \_\_\_\_\_

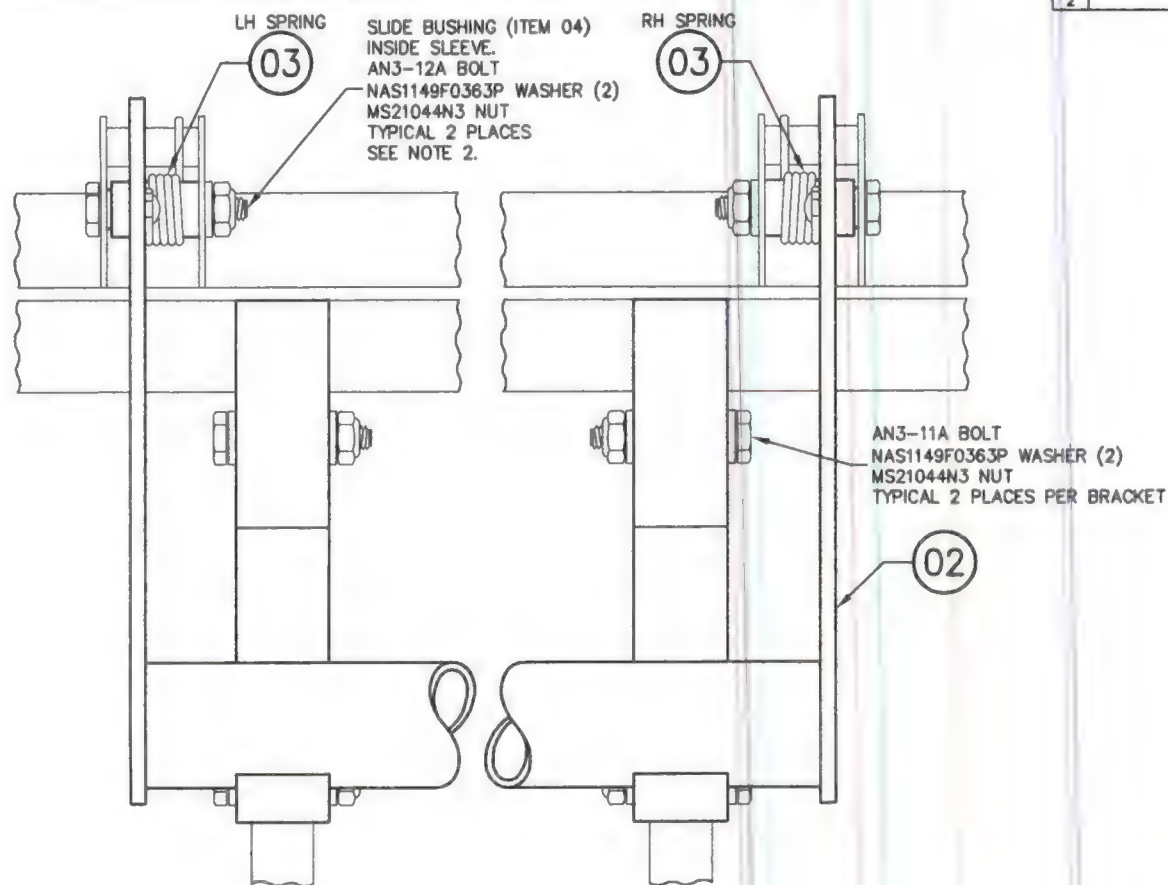
Approved Manufacturing Facility 73-04

Form 20.F.06

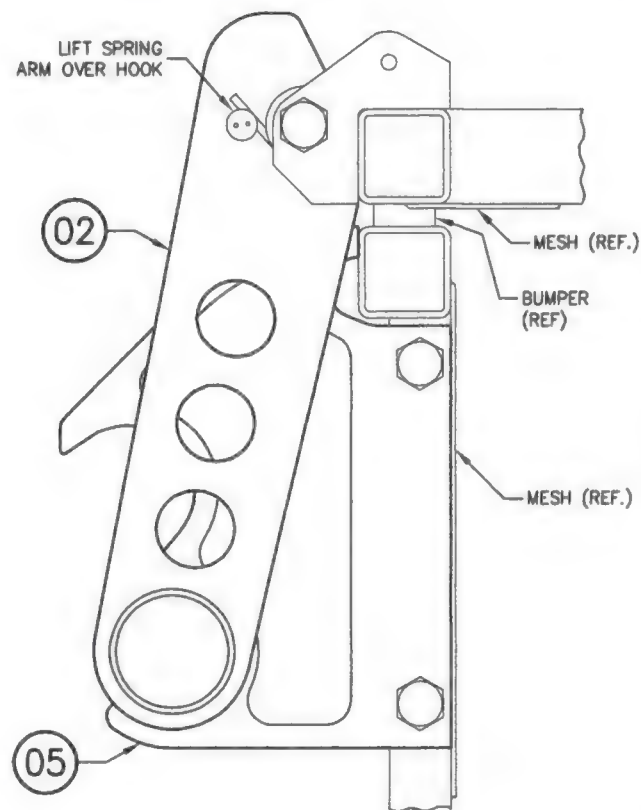
Rev. Original 27 May 2013

NOTES:

1. THIS DRAWING IS AN ALTERNATE CONFIGURATION FOR THE HANDLE INSTALLATION SHOWN ON DRAWING 36255.
2. GREASE BUSHING (ITEM 04) USING MOBILGREASE 28 OR EQUIVALENT PRIOR TO INSTALLATION.



01 HANDLE INSTALLATION



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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE - CREATED FROM 36255	BJC	NOV 03/09
1	HANDLE END BRACKETS FLIPPED	BJC	SEPT 19/11
2	TITLE BLOCK UPDATED; ADD NOTE 2; HARDWARE UPDATED	BJC	MAR 13/14

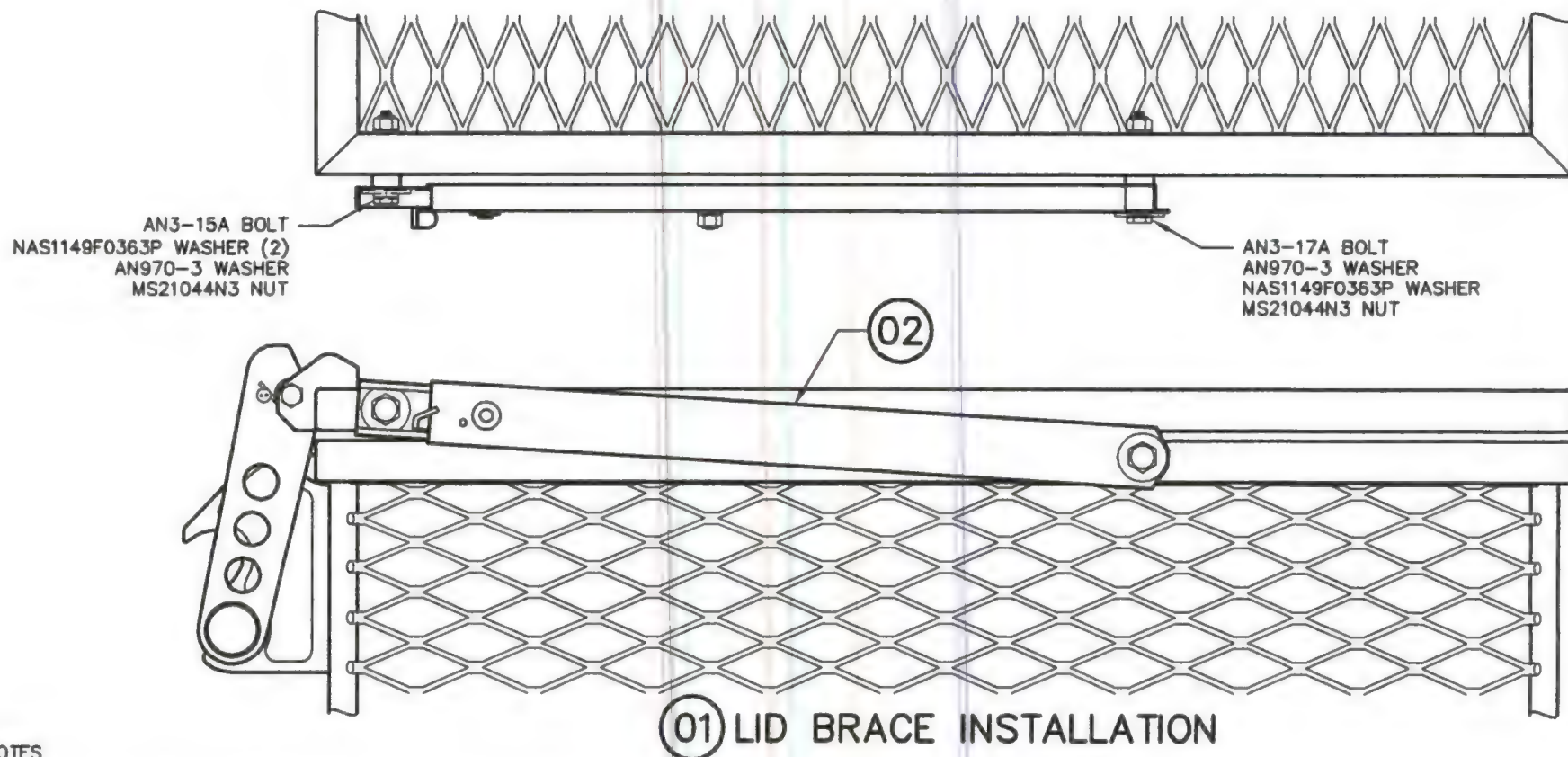
A/R	MOBILGREASE 28		GREASE		MIL-PRF-81322F
4	AN3-11A		BOLT		
2	AN3-12A		BOLT		
10	NAS1149F0363P		WASHER		
6	MS21044N3		NUT		
2	84267-01	05	BRACKET		
2	36275-01	04	BUSHING		
2	36278-01	03	SPRING (1 LH, 1 RH)		
1	84261-01	02	HANDLE BAR ASSEMBLY		
	84255-01	01	HANDLE INSTALLATION		
01	PART NO.	ITEM	DESCRIPTION		MATERIAL
QTY.	LIST OF MATERIALS				

APPROVALS	DATE
DRAWN: JEFF CLARKE	03 NOV 2009
CHECKED: E. BURGOIN	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2° X.XX ±0.03 X.X ±0.1	

 <b>AERO DESIGN LTD.</b> 9088A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 604.488.8876 www.aerodesign.ca		<b>HELICOPTER CARGO BASKET HANDLE BAR INSTALLATION</b>	
SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A3	84255	2


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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE	*	*



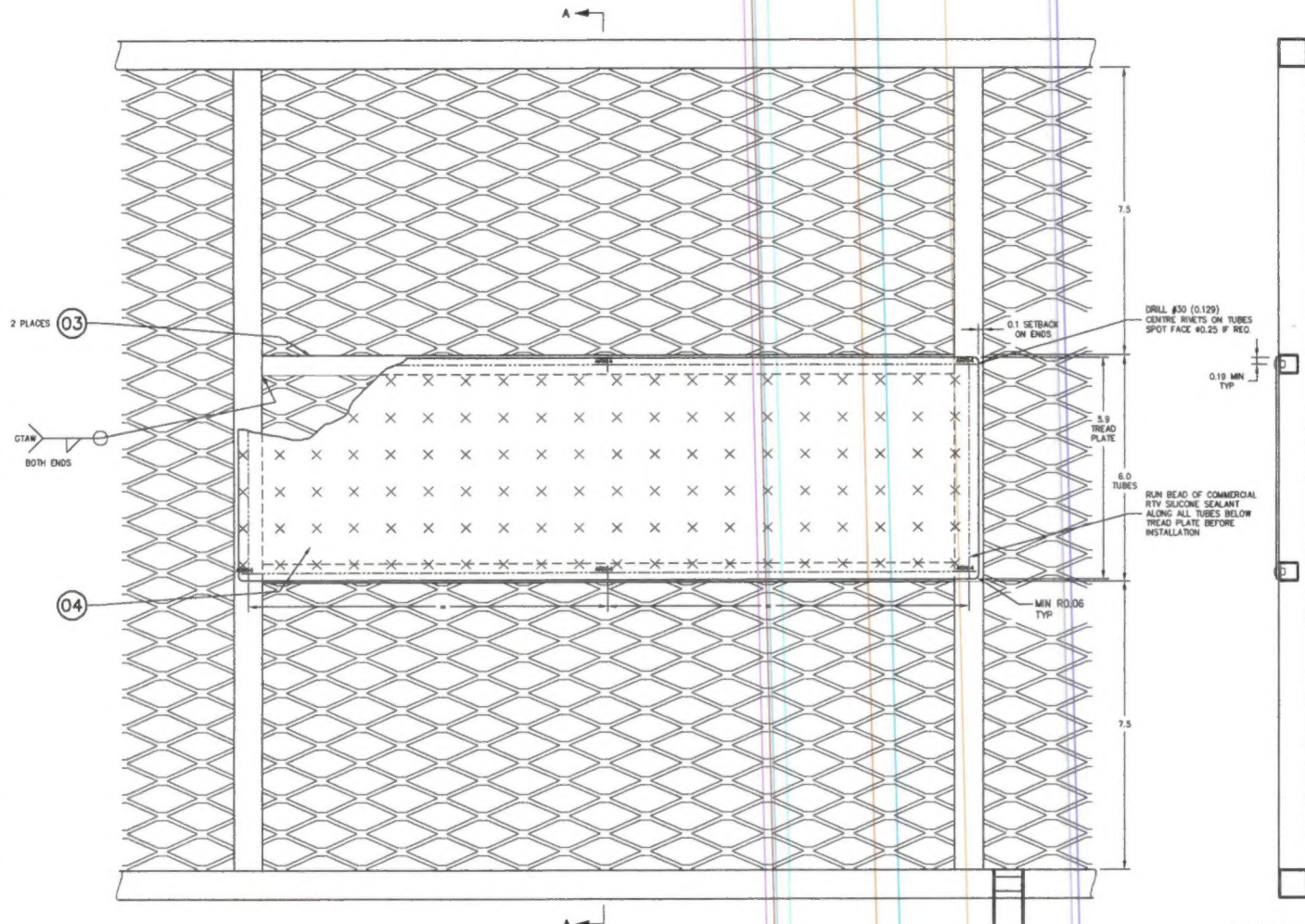
#### NOTES

- THIS DRAWING APPLIES TO ALL AERO DESIGN LTD. CARGO BASKET ASSEMBLIES.  
LID PROP IS TO BE INSTALLED ON THE FORWARD END OF THE BASKET AS INSTALLED ON THE HELICOPTER.

2	MS21044N3		NUT	APPROVALS		DATE			<b>AERO DESIGN LTD.</b> 9000A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 804-480-2976      www.aerodesign.ca				
3	NAS1149F0363P		WASHER	DRAWN: JEFF CLARKE		21 MAY 2014							
2	AN970-3		WASHER	CHECKED: JASON REKVE		21 MAY 2014							
1	AN3-17A		BOLT										
1	AN3-15A		BOLT							<b>HELICOPTER CARGO BASKET</b> <b>ALL MODELS</b> <b>LID BRACE INSTALLATION</b>			
1	36280-01	02	LID BRACE ASSEMBLY	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS                      ANGLES X.XXX ±0.010                      ±1/2" X.XX ±0.03 X.X ±0.1									
	84240-01	01	LID BRACE INSTALLATION										
01	PART NO.	ITEM	DESCRIPTION										
QTY.	LIST OF MATERIALS							NOT TO SCALE		DWG. SIZE	DWG. NO.	REV.	
								SHEET 1 OF 1		A4	84240	0	



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REV	DESCRIPTION OF CHANGE	INITIALS	DATE
1	ADD BELL MEDIUM AND EUROCOPTER AS350 BASKETS, CHANGE TUBES	B.J.C.	MAR 19/08
2	ADD EUROCOPTER EC135, MCDONNELL DOUGLAS MD500, BELL 206B BASKETS	B.J.C.	DEC 4/08
3	ADD NEW AS350 AND 206L/407 MODELS	B.J.C.	DEC 4/08
4	TITLE BLOCK UPDATED; MODEL LIST REMOVED; ADD ALT. RIVET; ADD NOTE 7	B.J.C.	28/05/2014



(01) BASKET LID ASSEMBLY

SECTION A-A

#### NOTES:

- THIS DRAWING IS AN OPTIONAL CONFIGURATION ADDING A TREAD PLATE STEP TO THE LID. THIS CONFIGURATION MAY BE APPLIED TO ANY OR ALL BAYS OF THE LID. REMAINDER OF LID ASSEMBLY IS TO BE FABRICATED IN ACCORDANCE WITH THE APPLICABLE DRAWINGS.
- TUBES (ITEM 03) MUST BE WELDED IN PLACE BEFORE MESH IS WELDED ON BOTTOM.
- REMOVE ALL BURRS AND BREAK SHARP EDGES.
- WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 2685C. WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT.
- WHEN ASSEMBLY IS COMPLETE, FILL ALL VENT HOLES WITH ROSETTE WELD.
- THOROUGHLY CLEAN AND POWDER COAT BASKET SUB-ASSEMBLIES PRIOR TO ASSEMBLY. INSTALL TREAD PLATE AFTER POWDER COATING.
- WIDTH AND POSITION OF LID STEP MAY BE ADJUSTED TO MATCH LID DOOR INSTALLED IN ACCORDANCE WITH DRAWING 70402 ON ADJOINING BAY OF THE LID.

A/R	CR3213-4-02	BLIND RIVET	ALTERNATE: HR3213-4-02			
1	70405-04	04 TREAD PLATE	ALUMINUM	COMMERCIAL	0.083 TREAD PLATE	
2	70405-03	03 TUBE	4130 STEEL COND. N	ML-T-6736	0.5 X 0.035 WALL TUBE	
1	SEE NOTE 1	02 BASKET LID ASSEMBLY				
1	70405-01	01 BASKET LID ASSEMBLY - MODIFIED WITH STEP				
QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
				LIST OF MATERIALS		

BASIC CODE REF. HAS 523 C=COUNTERSINK D=DIMPLE DIT=# OF SHEETS TO BE DIMPLED		DASH NO. FOR DIAMETER H=MFD. HEAD NEAR SIDE F=MFD. HEAD FAR SIDE DASH NO. FOR LENGTH		APPROVALS DRAWN: JEFF CLARKE CHECKED: E. BURGON		DATE 21 SEPT 2008	
BASIC CODES: BJ=MS20470AD BB=MS20426AD ABX=CR3213 ARM=CR3212		+ INSTALL NEW RIVET + REMOVE/REPLACE RIVET - EXISTING RIVET		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2" X.XX ±0.03 X.X ±0.1		AERO DESIGN LTD. 8888A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 804.463.5578 www.aerodesign.ca	
LID STEP MODIFICATION				SCALE 1:1.5 SHEET 1 OF 1		DWG. SIZE A1	
DWG. NO. 70405				REV. 4			



REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	INCREASE LOAD TO 250 LBS / 113 KG	BJC	27/01/2010
2	UPDATE TITLE BLOCK; UPDATE ADDRESS AND LOGO; MAT'L THICKNESS CHANGED	BJC	10/07/2014

# NOTES

- ENGRAVE 0.007 DEEP AS FOLLOWS:  
"QUICK RELEASE BASKET" - 0.125 HIGH  
"EUROCOPTER AS350 & AS355 SERIES" - 0.080 HIGH  
"S/N 78401-XX" - 0.080 HIGH  
"MAXIMUM PERMISSIBLE LOAD" - 0.125 HIGH  
"250 LBS/113 KG" - 0.200 HIGH  
"AERO DESIGN LTD." - 0.125 HIGH  
"POWELL RIVER, BC, CANADA" - 0.080 HIGH  
"www.aerodesign.ca" - 0.080 HIGH


DRILL #30 (0.129)  
4 PLACES



① PLACARD

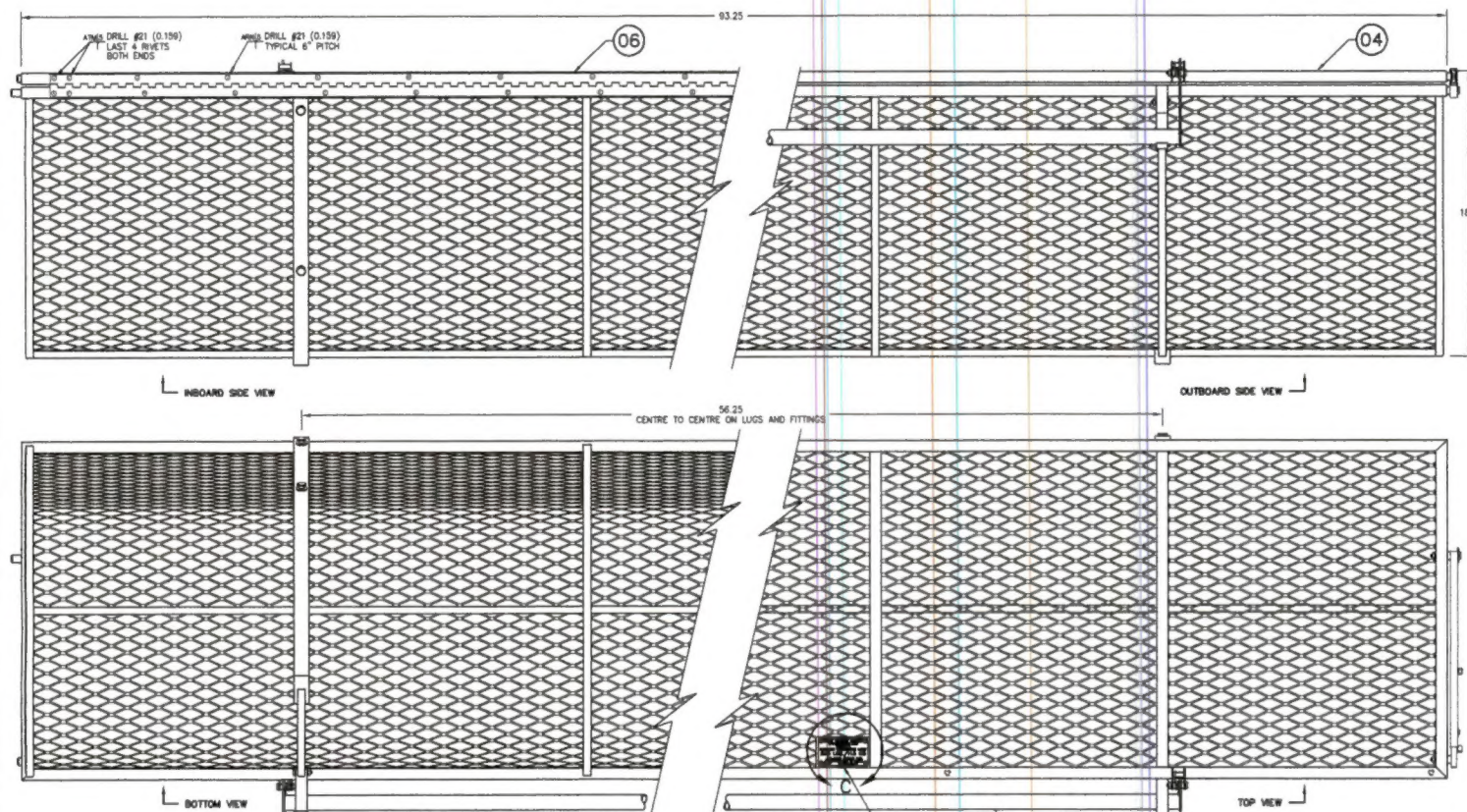
78427-01	01	PLACARD	6061-T6 ALUMINUM	QQ-A-250/11	0.050 SHEET
PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE

# LIST OF MATERIALS

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	DRAWN: R. RATHWELL		18 FEB 08			
	CHECKED: E. BURGAIN					
	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS      ANGLES X.XXX ±0.010      ±1/2" X.XX ±0.03 X.X ±0.1				<b>EUROCOPTER AS350 &amp; AS355 SERIES</b> <b>QUICK RELEASE CARGO BASKET</b> <b>PLACARD</b>	
	SCALE 1 : 1 SHEET 1 OF 1		DWG. SIZE <b>A4</b>	DWG. NO. <b>78427</b>	REV. <b>2</b>	

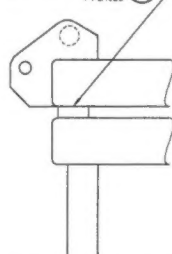


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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	CHANGED HANDLE CONFIGURATION, REMOVED ALTERNATE BASKET	BUC	27/01/2010
2	UPDATE TITLE BLOCK; ADD ALTERNATE RIVETS; HARDWARE P/N'S UPDATED;	BUC	16/07/2014
	HINGE LENGTH; CHANGE BRACE ASSEMBLY TO INSTALLATION		

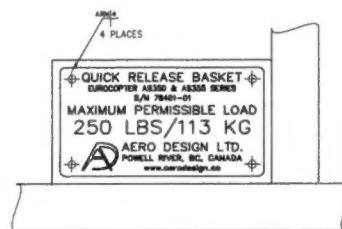


01 CARGO BASKET ASSEMBLY

FILL 1/4" HOLE WITH COMMERCIAL SILICONE SEALANT  
INSERT BUMPER INTO HOLE  
4 PLACES



BUMPER INSTALLATION  
SCALE 1 : 1



DETAIL C

SCALE 1 : 1  
LOOKING AT PLACARD BRACKET

NOTE:  
1. ALL DIMENSIONS SHOWN ARE FOR REFERENCE ONLY. DIMENSIONS OF COMPONENTS AND COMPLETE ASSEMBLY ARE DETERMINED IN PREVIOUS STEPS.

A/R	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
4	96710-01	FITTING				
8	CR3523-5-02	CHERRY RIVET				
A/R	CR3213-5-02	CHERRY RIVET				
4	CR3213-4-02	CHERRY RIVET				
4	49205-14	09 BUMPER				
1	78427-01	08 PLACARD				
1	84255-01	07 HANDLE BAR INSTALLATION				
A/R	MS20001P4	06 PLANO HINGE				90.0 LONG
1	84240-01	03 LID BRACE INSTALLATION				
1	78412-01	04 LID ASSEMBLY				
1	78411-01	02 BASKET BODY ASSEMBLY				
1	78410-01	01 CARGO BASKET ASSEMBLY				
D1	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY						

LIST OF MATERIALS

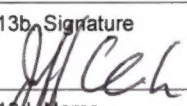
BASIC CODE	DASH NO. FOR DIAMETER	APPROVALS	DATE
REF. NAS 523	N=MFD. HEAD NEAR SIDE F=MFD. HEAD FAR SIDE	DRN: R. RATHWELL	19 FEB 08
C-COUNTERSINK	DASH NO. FOR LENGTH	CHECKED:	
D=DMPL		E. BURGIN	
DIST=# OF SHEETS TO BE DMPLD			
BASIC CODES:			
BJ=MS20470AD	+ U INSTALL NEW RIVET		
BB=MS20428AD	+ U REMOVE/REPLACE RIVET		
ABW=CR3213	+ U EXISTING RIVET		
ATW=CR3523			

**AERO DESIGN LTD.**  
9808A MALASPINA ROAD  
POWELL RIVER, BC, CANADA, V8A 0G3  
TEL: 855.463.5378 www.aerodesign.ca

EUROCOPTER AS350 & AS355 SERIES  
QUICK RELEASE SKI BASKET  
BASKET ASSEMBLY (LONG)

SCALE 1 : 4	DWG SIZE	DWG NO.	REV.
SHEET 1 OF 1	A1	78410	2



1. Approving Civil Aviation Authority/Country <b>Transport Canada</b>		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No. <b>2017-0326</b>
4. Organization Name and Address <b>AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3</b>					5. Work Order/Contract/Invoice <b>WO 2017-143</b>
6. Item <b>1.</b>	7. Description <b>Long Cargo Basket</b>	8. Part Number <b>78410-01</b>	9. Qty. <b>1</b>	10. Serial/Batch No. <b>78401-68</b>	11. Status/Work <b>New</b>
12. Remarks <b>Modified with walkway on lid IAW DCL704</b>					
13a. Certifies that the items identified above were manufactured in conformity to:  <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12 Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature 		13c. Approved Organization Number <b>AMF 73-04</b>		14b. Signature	
13d. Name <b>Jeff Clarke - AD02</b>		13e. Date (dd/mm/yyyy) <b>30 Aug 2017</b>		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mm/yyyy)	
<b>Installer Responsibilities</b>					
This certificate does not constitute authority to install. Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified. Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.					

**AIRBUS HELICOPTERS / CONRAD + BISCHOFF**